

Work Order ID 153562

Monday, November 21, 2016 2:24:59 PM

153562

Page 1

Item ID: D3447-7 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Clevis
 Start Date: 11/21/2016 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 11/30/2016 Req'd Qty: 6.00 ***6*** Customer:
 Reference: REWORK PER ECN 16-655

Approvals: Process Plan: mf Date: 16-11-21 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3447	Rev <u>AB</u> <u>16.12.15</u>

100		0.00				5	1		DAS 32 9-89 16-11-30
100									
Mill Conv	Memo	0.00							
Conventional Milling Machine	PULL FROM STOCK D3447-7 X 6 B142212								
	REWORK TO NEW DRAWING								

110	QC5- Inspect part completeness to step on W/O	0.00							PTO
110									
QC	Memo	0.00							
Quality Control									

120	Identify as per dwg & Stock Location: <u>MEZZZ</u>	0.00							
120									
Packaging	Memo	0.00							
Packaging									

mf 16-12-01 5 DAS
11
9-89

DQA:

Date: JKW 3 2017

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: DEC 16 2016Work Order update only ☐

Work Order: <u>153 562</u> Part No. <u>D3441-7</u> NCR No. <u>16-6163</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☒</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☒	Composite ☐	Supplier ☐																																																																									
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Description Work Order Deviation Qty of 1 was found from stock with hole drill at .315" Not able to perform rework. because hole is already oversize.				Disposition scrap destroy qty ① no replace				Completed By JKW 16-11-30																																																																																							
				Lead hand / Supervisor Approval Verification DAS 9 9-89 <u>16-11-30</u>																																																																																											
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Work Order ID 153562***153562***

Page 2

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Item ID: D3447-7 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Clevis
Start Date: 11/21/2016 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 11/30/2016 Req'd Qty: 6.00 ***6*** Customer:
Reference: REWORK PER ECN 16-655

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21 - Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

16/12/15 *[Signature]*
MF
16-12-01

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause			FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
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Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
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Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :						
Misidentified	☐	Past Due	☐							

Monday, November 21, 2016 2:24:59 PM

153562

D3447-7

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3447-7		Manufactured	No				Each	0.0000		6			
D3447-7 Clevis													
									**	142212		June	

16-11-21

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____					
Misidentified ☐	☐ Past Due						

List Lots

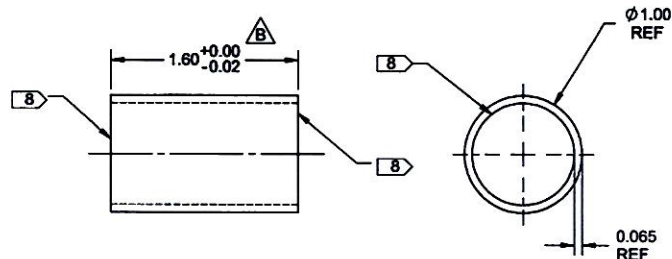
Monday, November 21, 2016 2:02:09 PM

Page 1 of 1

Criteria : Item ID: d3447-7 All Locations All Warehouses All Quantity

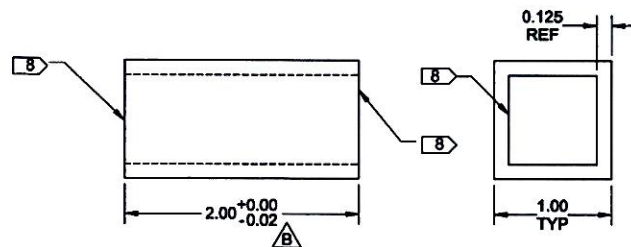
Item ID Item Name	Warehouse ID Location ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt Lot Code	Type Code	Comments
D3447-7 Clevis	Main Warehouse Mezz2	142212	8/2/2016	6.0000	QC21		
Total:				6.0000			

#153562.



D3447-1 ROUND SPACER

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR
ASTM B221
REF. DART SPEC. M6061T6T1.000W.065



D3447-3 SQUARE SPACER

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) SQUARE TUBING
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF. DART SPEC. M6061T6T1.000W.125

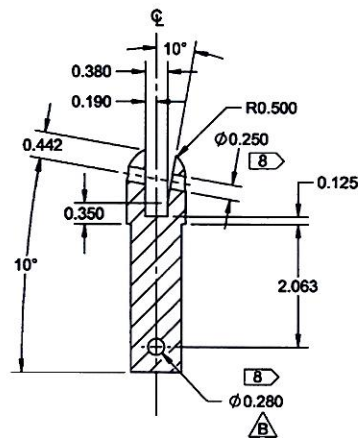
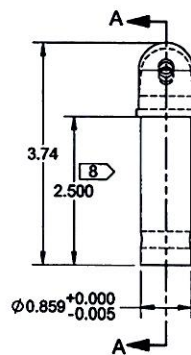
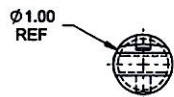
NOTES:

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A OR PER QSI 044 6.1
- 7) WEIGHT: D3447-1 = 0.03 lbs; D3447-3 = 0.09 lbs
- 8) MASKING: INSIDE OF TUBING AND ENDS BEFORE PAINTING.

RELEASED
2016-11-09

APPROVED

B	REDRAW TO CURRENT STD: 00.280 WAS 00.250 (ZN B3-2) AND (ZN C6-3), ADD TOLERANCE (ZN B5/D5-1), UPDATED MATERIAL SPECIFICATION, REASON PAR15-437	SAD	16.08.26
A	NEW ISSUE	MB	05.07.19
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SAD		
CHECKED	MB	DRAWING NO.	REV. B
MFG. APPR.	JLM	D3447	SHEET 1 OF 4
APPROVED	WM	TITLE	SCALE
DE APPR.	N/A	BLADE FOLD KIT PARTS	NTS
DATE	16.08.26	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD	



SECTION A-A

D3447-5 CLEVIS
SUPERSEDES PREMIER P/N B67-43001-99

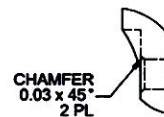
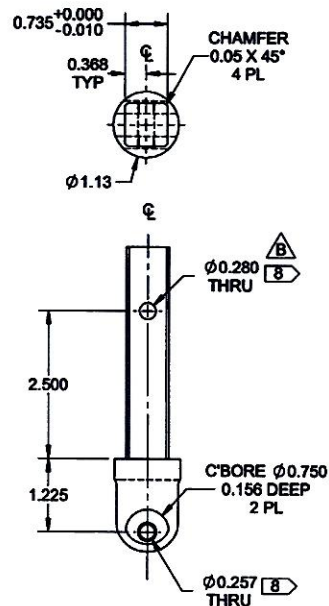
NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) ROUND BAR
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
 PER AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR
 ASTM B221
 REF. DART SPEC. M6061T6R1.000
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3.
- 3) TOLERANCES: ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EAGED 0.005 TO 0.010
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.07 lbs
- 8) MASKING: COVER LOCATION AND INSIDE HOLES AS SHOWN PRIOR TO PAINTING

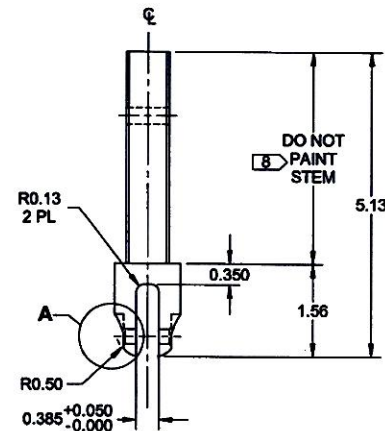
RELEASED
 2016-11-09

APPROVED

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	SAD	HAWKESSBURY, ONTARIO, CANADA	
CHECKED	MB	DRAWING NO.	REV. B
MFG. APPR.	JLM	D3447	SHEET 2 OF 4
APPROVED	WM	TITLE	SCALE
DE APPR.	N/A	BLADE FOLD KIT PARTS	NTS
DATE	16.08.26	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



DETAIL A
SCALE 1:1



D3447-7 CLEVIS
SUPERCEDES PREMIER P/N B67-43001-145/-345

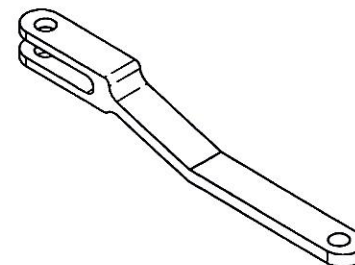
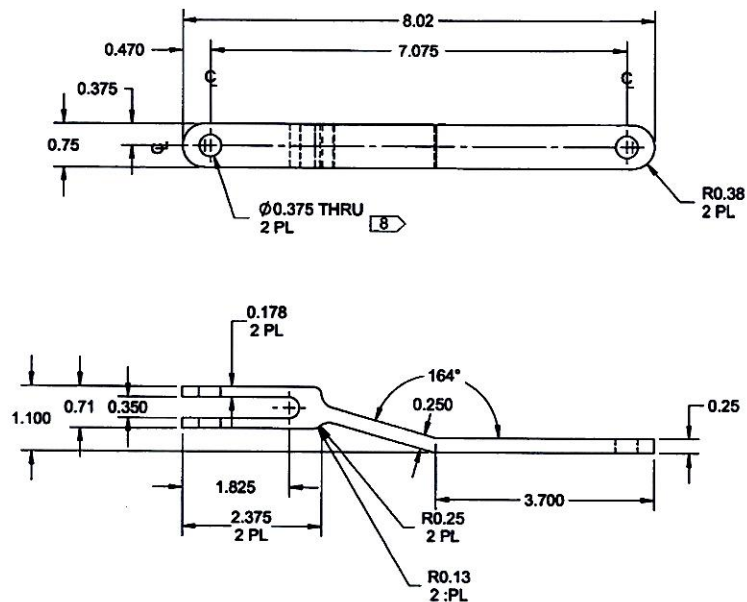
NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR
ASTM B221
REF. DART SPEC. M6061T6R1.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EAGED 0.005 TO 0.010
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs
- 8) MASKING: COVER INSIDE HOLES AS SHOWN PRIOR TO PAINTING

RELEASED
2016 -11- 09

APPROVED

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MB	DRAWING NO.	REV. B
MFG. APPR.	JLM	D3447	SHEET 3 OF 4
APPROVED	WM	TITLE	SCALE
DE APPR.	N/A	BLADE FOLD KIT PARTS	NTS
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D3447-9 SWING ARM

SUPERSEDES PREMIER P/N B67-43001-263

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR
ASTM B221
REF. DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.33
- 3) TOLERANCES: ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EAGED 0.005 TO 0.010
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.06 lbs
- 8) MASKING: COVER INSIDE HOLES AS SHOWN PRIOR TO PAINTING

RELEASED
2016-11-09

APPROVED

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA	
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